



FUNCTION OF TOOL

- 1 THE 145G0145-1 HOLDING FIXTURE WILL BE USED TO SECURE 145D5305 COLLECTOR GEAR DURING INSTALLATION/REMOVAL OF LOCKNUT IN THE 145D5300 COMB XMSN.
- 2 SHIM GEAR CENTRAL ON -12 PILOT DIA WHEN MAKING CERRO CAST.
- 3 MAKE FROM DIRECT CAST OF P/N 145D5305 COLLECTOR GEAR DEVCON B PLASTIC STEEL. RELEASE COAT P/N 145D5305 USE -17 LIQUID RELEASE AGENT.
4. BOLT & DOWEL CONST.
- 5 APPLY LIGHT COAT OF OIL, PER MIL-L-7808 TO ALL STEEL
- 6 STEEL STAMP (.12 HIGH CHARACTERS) IDENT PLATE SHOWN BELOW:
P/N 145G0145-1
NAME _____
CONTR NO. _____
INSP. _____
S/N _____
7. TOLERANCES: .X $\pm .2$
.XX $\pm .06$
.XXX $\pm .010$
ANGLES $\pm 1/4^\circ$
8. BREAK ALL SHARP EDGES .02 RAD. OR CHAMFER EXCEPT AS NOTED.
9. ALL MACHINED SURFACES TO BE 125° UNLESS OTHERWISE NOTED.
10. DEVCON CORP
DANVERS, MA 01923-3753
CODE IDENT NO 16059
11. THE 145G0145-1 HOLDING FIXTURE HAS BEEN SUCCESSFULLY DEMONSTRATED PER FIT & FUNCTION DEMONSTRATION REPORT NO. 47-257F.

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE	APPROV
A		REVISED PER DCN REY A	89-4-4 9/127/89 2/17/90 9/10/90	E. WACHA P. MARTE M. J. JONES R. C. AMAR

S.A.M. 06-05-90					
PROJ ASB#	DATE	BOEING VERTOL COMPANY			
<i>Mayer</i>	90-05-15	DCN	DRAWING NO. 77272		
REASON		COMP IDENT. NO.			
UPDATE DWG AFTER SUCCESSFUL FIT & FUNCTION DEMONSTRATION		14SG0145			
TATL & PROC		SR.	REV.		
		1	A		
Dwg		MATERIAL NO.			
<i>John Cusack</i>		414-100			
5/10/90		PIN			
Dwg Upd		CH-47D / 26300			
ORIGIN		CHANGE NO.			
GSE 7931		WAG325X			
CODE		SPARS AFFECTED			
PART OR IDENTIFYING NO.		CLASS PER MIL-STD-460			
		<input type="checkbox"/> CLASS I	<input checked="" type="checkbox"/> CLASS II		
NOMENCLATURE OR DESCRIPTION		ZONE	MATERIAL AND SPECIFICATION		
			HT TR FINISH PT MK		
DETAIL NO	QTY	NAME OF DETAIL	MATERIAL STOCK SIZE		
1	1	FIXTURE ASSY			
13	1	BACN12Mwg VSACH34 IDENT PL			
		PART I NEW CHANGES			
II TO G/N FIT & FUNCTION NOTE S-1 HOLDING FIXTURE SHALL BE DEMONSTRATED IN ACCORDANCE D FUNCTION TEST REPORT NO. 47-257F.					
RATION OF ADCN # 1					
D FLAG NOTE 3 FLAG NOTE 10 REVISED CALL-OUT FOR -16, DEVCON B CAST , ADDED APPLICATION BLOCK FOR MODELS CH-47D & 414-100 ADDED -16 & -17					
PART NO.		NEXT ASSY	USED ON	EFFECTIVITY	DWG SHL. NO.
		APPLICATION			

CUSTOMER SIGNATURE
ON RECORD
ONE-HALF SCALE
COPY OF ORIGINAL DW

QUANTITY	NAME OF DETAIL	SIZE	MATERIAL	STOCK SIZE		
1	LIQUID RELEASE AGENT		DEVCON P/N 19600	10 3		
1	DEVCON B PLASTIC STEEL		DEVCON P/N 10220	10 3		
1	BASE PL	HRS	3 1/4 X 20 1/2 SQ			
4	MS24630-4 SCR, SEL TAP		# 2 X 5/16 LG CRES			
1	BACN12MIWG IDENT P		BOEING IDENT P			
1	PLUG ALUM TOOL	1 1/2 X 1 1/4 SQ	1/2	1 1/2		
1	RING	HRS	1 X 1 1/4 SQ.			
1	RING	HRS	X 8 X 8			
3	CLAMP PAD	CRES	1 X 2 X 2			
8	SOG HD CP SCR		3/8-16 X 1 1/4			
2	RISER	CRES	1 X 1 1/2 X 20 1/2			
6	HEX NUT		1/2-13 UC			
3	HEX HD CP SCR		1/2-13 X 2			
4	FLAT WASHER	STU	1/2 I.D.			
3	HEX HD CP SCR		1 1/2-13 X 2 1/4			
2	CLAMP	CRES	3/4 X 2 X 5			
1	FIXTURE ASSY					
CONTRACT NUMBER						
DAAK50-83-C-0003						
DRAWN R.A. NAPOLEON 9-2-83						
CHK	C. L. CHAN	2-24-84	BOEING VERTOL COMPANY			
ENGR FERDINS	E. D. Zeeke	2/24/84	A DIVISION OF THE BOEING COMPANY			
ORG	J. Hengel	2-24-84	PHILADELPHIA, PENNSYLVANIA 19142			
PROJECT APPROVAL						
<i>J. Hengel</i> 2/26/84						
SIZE		CODE IDENT NO				
J		77272				
SCALE FULL			SH 1 OF 1			